Work Order ID 57557

Page 1

April 8, 2010 10:04:26 AM D3773-1 Accept Item ID: Setup Start **Revision ID:** Stop Item Name: Adapter 4/08/10 Start Qty: 4.00 **Start Date:** Cust Item ID: Req'd Qty: 4.00 Required Date: 4/16/10 **Customer:** Reference: Run Start Date: Tooling: Approvals: **Process Plan:** Date: **Stop** QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Draw Plan Reject Draw Accept Reject Insp. **Work Center ID** Description Rev. Qty Qty. Stamp **Run Hours** Number Code Number Draw Nbr **Revision Nbr** D3773 Rev B 100 0.00 **BAND SAW** nd 10/04/10 Bandsaw Memo Jeaspa Bandsaw Cut blank 2.700" long 110 HAAS CNC VERTICAL MACHINING #1 1. 10/04/13 HAAS 1 0:00 1- Mill as per Folio FA740 Rev: $\Delta\Delta$ & Dwg D3773 Rev: β HAAS CNC vertical machine #1 per dwg D3773 120 QC2- Inspect parts off machine FAI/FAIB.

QC

0.00

1.8 w/ou/13

Memo

0.00

Quality Control

W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PR	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto	
Part No				gory:					
		NULION:	HIEROEHIOF	>•	OA. NICCO	locad.		Data.	
NCR:	11000			n: ER NON-CONFORMAN				Date:	
NCR:	11000		WORK ORDE	ER NON-CONFORMAN	ICE (NC			Date:	
NCR:	STEP		WORK ORDE		ICE (NC	R) Verifi	cation ion C	Approval Chief Eng	Approval
		Description of NC	WORK ORDE	Corrective Action Section Action Description	B Sign	R) Verifi	cation	Approval	Approval

NOTE: Date & initial all entries

Work Order ID 57557

Page 2

April 8, 2010 10:04:26 AM

Item ID:

D3773-1

Revision ID:

Item Name: Adapter

Start Date:

4/08/10

Start Qty: 4.00

Required Date: 4/16/10

Req'd Qty: 4.00



Accept

Date:

Date:

Draw

Rev.

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling: Date:

SPC (Y/N):

Draw

Number

Stop

Oty

Start



Sequence ID/ **Work Center ID**

130



Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

0.00

0.00

Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

Identify as per dwg & Stock Location: 247

0.00

0.00

Run

140

Packaging

Packaging

Memo

150

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace	Ltd
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W/O:			V	ORK ORDER CHAN	NGES		-		· ,	
DATE	STEP	PROCEDURE CHANGE By Date				Date Qty Approval Chief Eng / Prod Mgr QC I				
									Floativigi	· · · · · · · · · · · · · · · · · · ·
Part No	:	PAR #:	Fault Ca	tegory:	NCF	: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposit	ion:	QA:	N/C Cld	osed:	d: Date:		
NCR:			WORK OR	DER NON-CONFOR	MANCE	(NCR)			
DATE	CTED	Description of NC		Corrective Action S	Section B		Verific	ration	Approval	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Descriptio Chief Eng	n	Sign & Date	Secti		Chief Eng	Approval QC Inspector
										-
							<u> </u>			
					·					

NOTE: Date & initial all entries

Picklist Print

April 8, 2010 10:04:25 AM

Work Order ID: 57557

Parent Item:

Parent Item Name: Adapter

cm rame. Adapter

Comments: IPP Rev:A New Issue 08-05-07 JLM Verified By:DD

D3773-1



Start Date: 4/08/10

Required Date: 4/16/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	16.3000	0.9474			

304 bar 1.50 X1.50

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
MAT54	16.3		
108381	12		
112752	4.3		

.9474 ml 10/04/10

Dart Aerospace	Ltd
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W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Qty Approv		Approval QC Inspector	
						,		•	
									
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA:	Date: _		
							ed: Date:		
NCR:			WORK OR	DER NON-CONFORMA	ANCE (NCF	1)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	ion B	Verification		Approval	
		Section A	Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector	
								-	
						*	·		
				• .					
								-	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	57557
Description: Adapter	Part Number:	D3773-1
Inspection Dwg: D3773 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	201				
Ø1.010	+0.010/-0.000	1.013				
1.20	+/-0.030	1.186	/			
1.25	+/-0.030	1.245				
2.45	+/-0.030	2.440	/			
Ø1.010	+0.010/-0.000	1.012				
1.25	+/-0.030	1.250				
Ø0.201	+0.005/-0.001	,201	/			
1.20	+/-0.030	1.197				
•						
		<u> </u>		<u></u>		

	A				
Measured by:	28	Audited by:	DIP.	Prototype Approval:	N/A
Date:	0/04/13	Date:	10/04/13	Date:	N/A
			77		

Rev	Date	Chánge	Revised by	Approved
Α	08.07.24	New Issue	KJ/DD A	137
			·	



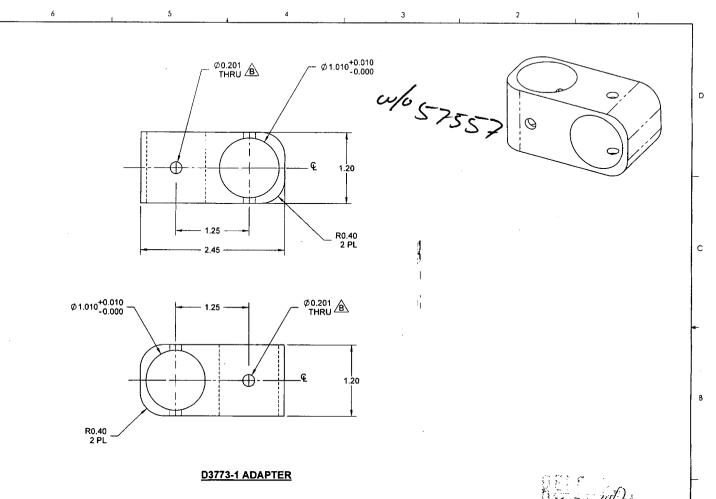
Lean principle

To be able to produce exactly:

- what is required
- when it is required
- the quantity required

by the next step in the process.

Once a job started, it should ideally never stop



NOTES:
1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.40 lbs

DESIGN DRAWN	HS HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	Pt 1	DRAWING NO.	REV. B
MFG. APPR.	Luth	D3773	SHEET 2 OF 3
APPROVED	.Alahi	TITLE	SCALE
DE APPR.	- M	HEADREST ADAPTER	NTS
DATE 08.06.24 COPYRIGHT © 2008 BY DART AEROSPACE LTD ING GOODWITH WAS AN COMPRETED ON THE EMPESS COMPINE THAT IT NOT TO BE LIGHT OF ANY PURPLES OF COMPINE OF THE COMPANIENT TO ANY PURPLES OF COMPINE OF THE PROPERTY OF THE			PRESS CONDITION THAT IT E.



Value stream mapping

 Value stream mapping is the best way to identify where the high payoff opportunities are, yet value stream mapping is the lean tool most likely to not be used by companies doing pretend lean!